

**Work Order ID 72634**

Wednesday, August 03, 2011 10:37:25 AM

Page 1

Item ID: DSK079

Accept

Revision ID:

Item Name: D2894-I TURNING DETAIL

Start Date: 8/2/2011 Start Qty: 6.00

Required Date: 8/12/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSK079

Rev A

100

0.00



MOXISERT CNC LATHE LARGE

0.00

Doosan

Memo

Doosan Lathe

Turn blank as per Folio FA253

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

ASAP



11.8.16

4

11.8.16

4

11.8.16

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72634**

Wednesday, August 03, 2011 10:37:25 AM



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Item ID: DSK079

Accept



Setup Start



Revision ID:

Stop



Item Name: D2894-1 TURNING DETAIL

Start Date: 8/2/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	... Identify and Stock in Kanban <input type="checkbox"/> Location: <u>calc</u>								
			<u>SL</u>	<u>1058116</u>					
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/8/18   
MK  
11-08-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 03, 2011 10:37:22 AM

Page 1

Work Order ID: 72634

Parent Item: DSK079

Parent Item Name: D2894-1 TURNING DETAIL

Start Date: 8/2/2011

Required Date: 8/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-009		Manufactured	No				Each	10.0000		6			
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Round Billet, 17-4



11.8.16

Location

Loc Qty

Loc Code

MAT043

10

41968

10

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	72634
Description: Turning Detail for D2894-1		Part Number:	DSK079
Inspection Dwg: DSK079	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

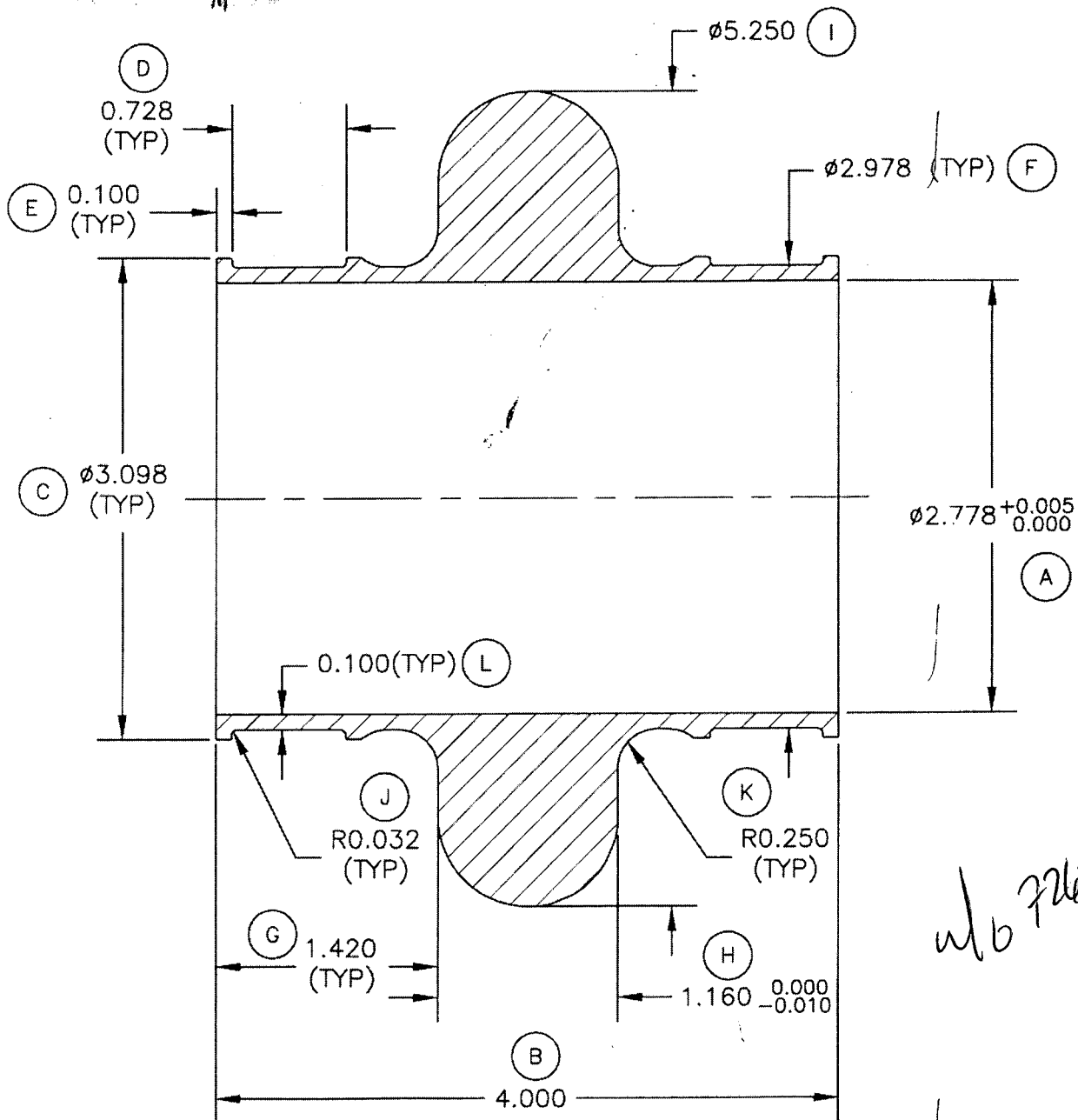
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.778	2.783	2.783	2.783	2.783	2.783	2.783	2.783
B	3.990	4.010	3.995	3.995	3.995	3.995	3.995	3.995
C	3.088	3.108	3.101	3.101	3.101	3.101	3.101	3.101
D	0.718	0.738	.727	.727	.727	.727	.727	.727
E	0.090	0.110	.102	.102	.102	.102	.102	.102
F	2.968	2.988	2.980	2.980	2.980	2.980	2.980	2.980
G	1.410	1.430	1.420	1.420	1.420	1.420	1.420	1.420
H	1.150	1.160	1.155	1.155	1.155	1.155	1.155	1.155
I	5.240	5.260	5.253	5.253	5.253	5.253	5.253	5.253
J	0.022	0.042	.032	.032	.032	.032	.032	.032
K	0.240	0.260	.250	.250	.250	.250	.250	.250
L	0.090	0.110	.100	.100	.100	.100	.100	.100

Measured by:	Date: 11.8.16
Audited by:	Date: 11/8/16
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DESIGN H	DRAWN BY A	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 079	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2894-1	SCALE 1:1
A	03.05.20	NEW ISSUE	



D2894-1 TURNING DETAIL

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries